

Date: Tuesday, 3/20/2007 2:36:14 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 31390 -1
Estimate Number : 10036
P.O. Number : N/A
This Issue : 3/20/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Fun : 25357
Written By :
Checked & Approved By :
Comment : Est. A: 01.05.04 New Issue EC

Drawing Name : SADDLE BILLET
Part Number : D6101013
Drawing Number : D6101 REV A
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 6/1/2007

Qty: 501 Um: Each

Additional Product

Job Number:

Seq. #

Machine Or Operation:

Description:

1.0

PG

PURCHASING

Comment: PURCHASING

Issue P/O: 2385

a) Description: Aluminum billet

b) 10.100" x 8.250" x 2.50" thick (+0.030 / -0.000)

c) Tolerance on all dimensions are +0.030 / -0.000"

d) Grain direction along 10.100" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

2.0

D6101013P

Saddle billet

Comment: Qty.: 1.0000 Each(s)/Unit Total: 501.0000 Each(s)

Saddle billet

3.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0

QC6

DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

Tuesday, 3/20/2007 2:36:14 PM

ar: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 31390

Part Number: D6101013

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ml 07/09/15

8

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/09/17

8

Job Completion



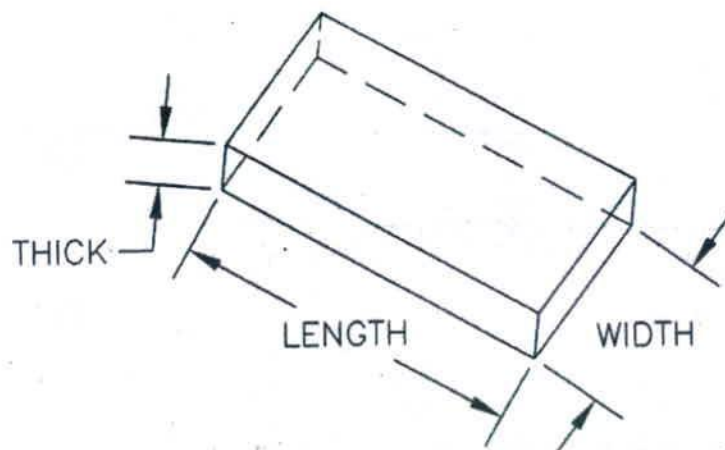
07/09/17



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *[Signature]*



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31390

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31 555704 996495 01

Métalux Castles

A.M. CASTLE & Co. (Canada) Inc.

EXPÉDIE 12 SEP. 2004

NO. REQUISITION CLIENT-CUSTOMER REQUISITION NO.

NO. COM. CLIENT-CUST. ORD. NO.

COMPTÉ-ACCT.

VEND. SLS

TERR.

EXPÉDIE PAR-SHIP VIA

3385

91037

200

40

TRUCK

MANITOULIN

ACHETEUR-PURCHASING AGENT

LINDA LACELLE

TELEPHONE

613 632-3336

H/C

TAXE

NO. COM. ORD.

1

C/C

REGION LIVRAISON-DEL. ZONE

F.A.B.-F.O.B.

PREPAID

BILL

NO. FEVILLÉ/EMBALLAGE-B/L NUMBRE

VIVRE A-SHIP TO:

VENDU A-SOLD TO:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

INFORMATION CRÉDIT-CREDIT INFORMATION

ROUTE

01-NL-09/

31-NL-09/

INSTRUCTIONS/LIVRAISON-DELIVERY

INO-H60156

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

DESCRIPTION - ITEM 1

2.5000 PLATE 7075-T7351 ALUM 8.25" X 10.10"

BLACK W/RED STRIPE

QTE/UNITE COM.-ORDERED

PCS

POIDS COM.-WT. ORDERE

8

PCS

16

BALLOTS-BUNDLES

PCS/PO EXP. SHIP.

POIDS EXP.-WT. SHIPPED

1

8

169

FORME-SHAPE

I.A.C.

6879

36.360000

COULÉE INFO-HEAT INFO QTE-QTY

401533AS

INSTRUCTIONS (CONT'D.)

8x8.25"x10.10"

N6

ENT.

DESCRIPTION - ITEM 2

TERMS AND CONDITIONS
OF SALESEE DISCLAIMERS AND LIMITATIONS
ON THE REVERSE SIDE

INSTRUCTIONS

1 Box
W/555699

COULÉE INFO-HEAT INFO QTE-QTY

INSTRUCTIONS (CONT'D.)

QTE/UNITE COM.-ORDERED

PCS

POIDS COM.-WT. ORDERE

BALLOTS-BUNDLES

PCS/PO EXP. SHIP.

POIDS EXP.-WT. SHIPPED

FORME-SHAPE

I.A.C.

ENT.

DESCRIPTION - ITEM 3

ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED
ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY
RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF
SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN
10 DAYS WHEN CREDIT IS REQUESTED.

INSTRUCTIONS

COULÉE INFO-HEAT INFO QTE-QTY

INSTRUCTIONS (CONT'D.)

QTE/UNITE COM.-ORDERED

PCS

POIDS COM.-WT. ORDERE

BALLOTS-BUNDLES

PCS/PO EXP. SHIP.

POIDS EXP.-WT. SHIPPED

FORME-SHAPE

I.A.C.

ENT.

NOM (LETTRE MOULÉE)-NAME (PRINT ONLY)

RECU PAR-RECEIVED BY

DATE RECU-
DATE RECEIVED

FEVILLÉ D'EMBALLAGE - PACKING SLIP

SHIP TO:
A M CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

SOLD TO:
AM CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4103569

CUSTOMER PO NUMBER: 01-84658		WORK PACKAGE:		CUSTOMER PART NUMBER: 6879 A97075-60		SHIP RUN/LOAD ID: 101025/16		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1052032	LINE ITEM: 1	SHIP DATE: 26-JUL-2007	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE			
WEIGHT SHIPPED: 7126 LB	QUANTITY: 4 PCS EST.	B/L NUMBER: 2013762		GAUGE: 2.5000 IN		WIDTH: 48.500 IN		LENGTH: 144.500 IN	

Certified Specifications

AMS 4078/RevG
ASTM B 209/Rev06
BSS 7055/RevA
DPS 4.713/RevN/AmdAF
GSS16100/RevG

AMS-QQ-A-250/12
ASTM B 594/Rev06
CMMP 025/RevR
EAC MS1011/RevD
MMS 159/RevN

AMS-STD-2154
BAC 5439/RevH
CSTI 006/RevC
GAMPS 9101/RevB
PS 21211/RevK

Test Code: 4297

Test Results

Lot: 401533A5 Cast 984

Drop 61

Ingot 2

(ASTM E8/B557)

Tensile: Temper
T7351

Dir / # Tests
LT / 2 (Min:Max)

Ultimate KSI (MPA)
70.1 : 70.1
(483 : 483)

Yield KSI (MPA)
58.8 : 59.1
(405 : 407)

Elongation %
10.8 : 11.0

(ASTM E1004)

Conductivity %IACS :
(MS/M) :

41.0 Min
23.8 Min

41.1 Max
23.8 Max

(ASTM E1251)

Chemistry:
Actual

SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHE
0.11	0.21	1.5	0.02	2.5	0.20	5.7	0.03	0.01	0.01	TOT 0.0

CASTLE METALS CORP.
DATE RCVD 7/30/07
IAC 6879
APPROVED BY Jim-2

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4103569

Lot: 405629A7 Cast 984 Drop 87 Ingot 3

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	70.3 : 70.6 (485 : 487)	59.1 : 59.1 (407 : 407)	10.4 : 10.9

(ASTM E1004)

Conductivity %IACS :	41.6 Min	41.8 Max
(MS/M) :	24.1 Min	24.2 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTH
Actual	0.11	0.20	1.5	0.02	2.5	0.19	5.6	0.02	0.01	0.01	TOT 0.

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	M/
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.

Aluminum Remainder

TEST NOTES

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM & CHEMICAL CORPORATION LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR



